

Work Order ID 84004

May-01-12 10:39:41 AM

84004

Page 1

Item ID: D3043-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Step Weldment LH, A119

Start Date: 01/05/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 15/05/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan: MLJ

Date: 2/05/01

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3043	Rev A

100

0.00

100

Large Fab

Large Fab

Memo

0.00

Large Fab

1-Cut D2622-120 extrusion to 120.00" long as per Dwg D3043 using cutting table setup DT8185-G
2-Deburr and bevel ends for welding

4

0

Ac

12.05.30

110

QC6- Inspect dimensions to drawing

0.00

110

QC

Memo

0.00

Quality Control

4

12.05.30

120

0.00

120

Large Fab

Large Fab

Memo

0.00

Large Fab

1-Weld 1 End Cap & Mounting Lugs as per QSI 004 & Dwg D3043 Using DT8802
AR AL ROD Batch: 120854
2-Grind Fwd End Cap weld flush

4

12.06.05

Ac
12.06.08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 84004

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May-01-12 10:39:41 AM

Item ID: D3043-041 Accept *N9000040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Step Weldment LH, A119
 Start Date: 01/05/2012 Start Qty: 4.00 *4* Cust Item ID:
 Required Date: 15/05/2012 Req'd Qty: 4.00 *4* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds Memo	0.00 0.00				4	0	86	12/06/12
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				4			
150 *150* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				4			MG 12-6-12

W/O:		WORK ORDER CHANGES					
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Required Date: 15/05/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

0.00

160

Large Fab

Large Fab

Memo

0.00

1-1-Weld 1 End Cap as per QSI 004 & Dwg D3043

AR AL ROD Batch: 120854

2-Inspect for foreign object as per QSI 024

3-Grind Fwd End Cap weld flush

4

0

12.06.12

Ac 12.06.13

170

QC10- Inspect visual per QSI004- ground welds

0.00

170

QC

Memo

0.00

5/17/06/14

Quality Control

180

QC5- Inspect part completeness to step on W/O

0.00

180

QC

Memo

0.00

5/17/06/14

Quality Control

24

14

W/O:		WORK ORDER CHANGES					
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Work Order ID 84004

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Item ID: D3043-041

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Step Weldment LH, A119

Start Date: 01/05/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 15/05/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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230

QC3- Inspect Part Finish

0.00

230

QC

Memo

0.00

Quality Control

12/6/18

240

Identify as per dwg & Stock Location: _____

0.00

240

Packaging

Memo

PPD 84002

0.00

Packaging

12/6/18

250

QC21- Final Inspection - Work Order Release

0.00

250

QC

Memo

0.00

Quality Control

12/6/18

ME 12-06-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

May-01-12 10:39:45 AM

Page 1

Work Order ID: 84004

84004

Parent Item: D3043-041

D3043-041

Parent Item Name: Step Weldment LH, A119

Start Date: 01/05/2012

Required Date: 15/05/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev :A New Issue JLM 05-11-01

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2622-120C

Manufactured No

100

Each

109.7300

1

4

D2622-120C

Step Extrusion

**

383894 (4) Ae 12.05.30

Location	Loc Qty	Loc Code
HALL	16.37	
46910	2	
64409	6	
66970	7.7	
68293	0.25	
72131	0.42	
WA	84	
81507	84	
WA013	9.36	
75781	2	
77612	7.36	

D3040-3

Manufactured No

100

Each

21.0000

2

8

D3040-3

Mounting Lug

**

12.05.31

Location	Loc Qty	Loc Code
WA018	21	
76998	21	

D2734

Manufactured No

120

Each

53.0000

1

4

D2734

Step End Plate

**

12.05.31

Location	Loc Qty	Loc Code
WA	53	
76985	25	
80682	28	

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

May-01-12 10:39:45 AM

Work Order ID: 84004

84004

Parent Item: D3043-041

D3043-041

Parent Item Name: Step Weldment LH, A119

Start Date: 01/05/2012

Required Date: 15/05/2012

Start Qty: 4.00

Required Qty: 4.00

D3040-1

Manufactured No

120

Each

41.0000

2

8

D3040-1

Mounting Lug

**

12.05.31

Location

Loc Qty

Loc Code

WA

41

77683

10

79722

10

80808

21

8

D2734

Manufactured No

160

Each

53.0000

1

4

D2734

Step End Plate

**

12.06.12

Location

Loc Qty

Loc Code

WA

53

76985

25

80682

28

1

3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3043	REV. A SHEET 1 OF 2
DATE 01.06.28		TITLE A119 STEP WELDMENT	SCALE NTS
A	01.06.28	NEW ISSUE	

PARTS LIST:

Qty -041	Qty -043	Part Number	Description
X		D3043-041	STEP WELDMENT, LH
	X	D3043-042	STEP WELDMENT, RH
1	1	D2622-120	STEP EXTRUSION
2	2	D3040-1	MOUNTING LUG
2	2	D3040-3	MOUNTING LUG
2	2	D2734	ENDPLATE

NOTES:

- 1) MANUFACTURE FROM D2622-120 EXTRUSION
- 2) WELD PER DART QSI 004. ALL WELDS SHOULD BE 100% VISUALLY INSPECTED BY A QUALIFIED INSPECTOR PER DART QSI 004
- 3) FINISH: ACID ETCH & ALODINE ASSEMBLY PER DART QSI 005 4.1
POWDER COAT WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT TOP SURFACE OF STEP TO BOTTOM OF TOP
RADIUS PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
01.07.05 *[Signature]*

SHOP COPY
RETURN TO
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WITHOUT NOTICE
WORK ORDER
NO. 84007 MJS
12/05/01

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Dart Aerospace Ltd

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

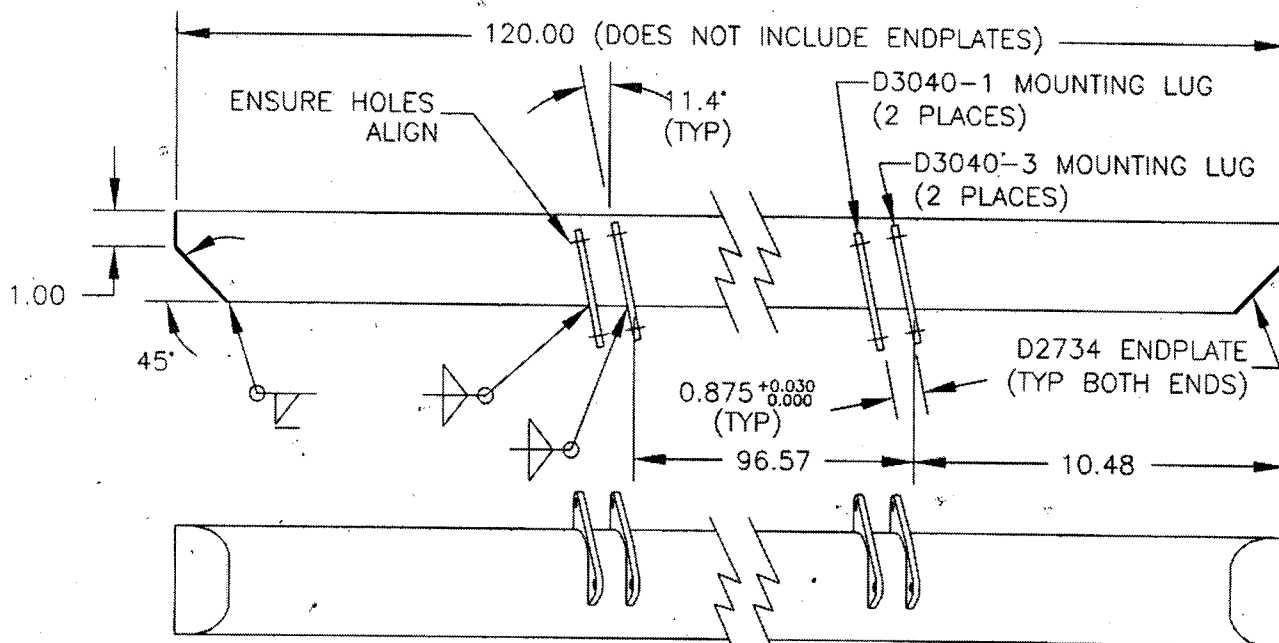
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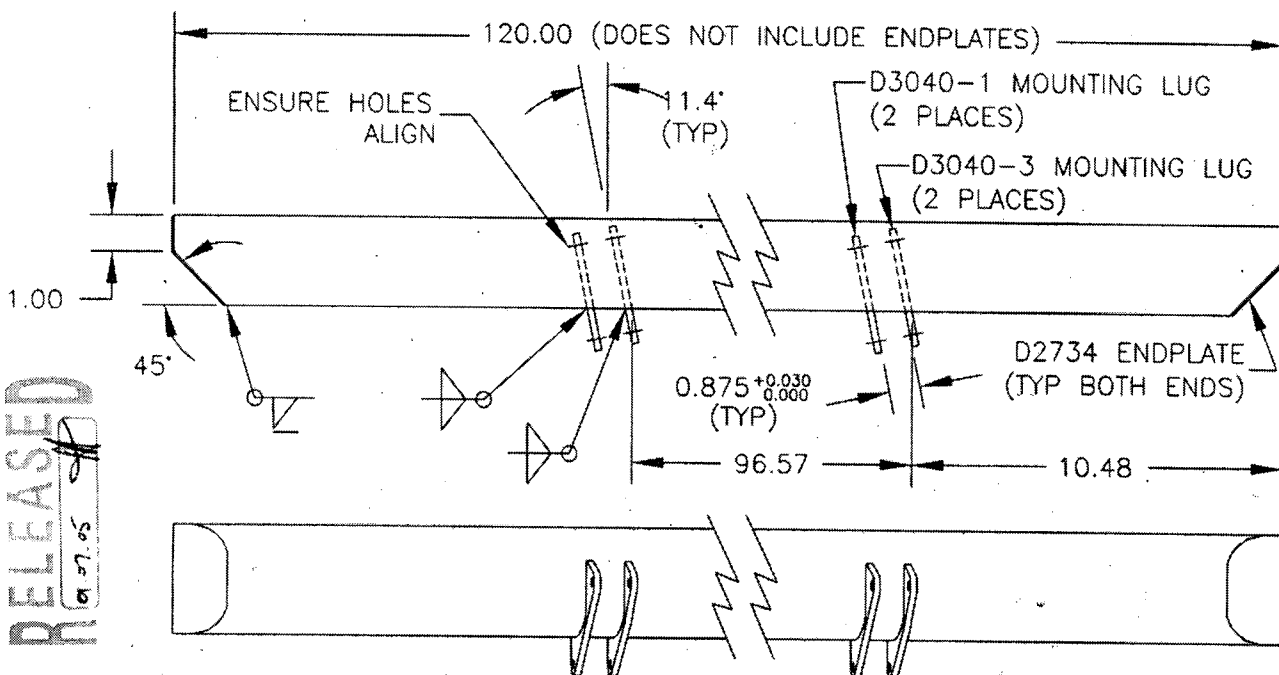
NOTE: Date & initial all entries



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CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3043	REV. A SHEET 2 OF 2
DATE 01.06.28		TITLE A119 STEP WELDMENT	SCALE 1:5
A	01.06.28	NEW ISSUE	



VIEW A-A: D3043-041 LH STEP WELDMENT



VIEW A-A: D3043-042 RH STEP WELDMENT

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Dart Aerospace Ltd

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